

5/29

DART AEROSPACE LTD	Work Order:	23627
Description: Bracket Assembly	Part Number:	D2804-042
Dwg: D2804 Rev. B	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler Dwg not required	HA	05.06.21	10																				
2	GA	Press D2805-2 into arm as per Dwg D2804 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2804-2</td> <td>Bracket</td> <td>B21305</td> </tr> <tr> <td>1</td> <td>D2805-2</td> <td>Stop</td> <td>B23637</td> </tr> <tr> <td>1</td> <td>D2809</td> <td>Bushing</td> <td>B22529</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2804-2	Bracket	B21305	1	D2805-2	Stop	B23637	1	D2809	Bushing	B22529	SB	05/09/26	10				
Qty	Part Number	Description	Batch																						
1	D2804-2	Bracket	B21305																						
1	D2805-2	Stop	B23637																						
1	D2809	Bushing	B22529																						
3	QC5	Inspect work to Step 2																							
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3																							
5	QC3	Inspect Powder Coat																							
6	GA	Press D2809 into arm as per Dwg D2804																							
7	GA	Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>AN3C16A</td> <td>Bolt</td> <td></td> </tr> <tr> <td>2</td> <td>MS21043-3</td> <td>Nut</td> <td></td> </tr> <tr> <td>4</td> <td>NAS1515H3</td> <td>Washer</td> <td></td> </tr> <tr> <td>A/R</td> <td>LPS-3</td> <td>Corrosion Spray</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	AN3C16A	Bolt		2	MS21043-3	Nut		4	NAS1515H3	Washer		A/R	LPS-3	Corrosion Spray				
Qty	Part Number	Description	Batch																						
2	AN3C16A	Bolt																							
2	MS21043-3	Nut																							
4	NAS1515H3	Washer																							
A/R	LPS-3	Corrosion Spray																							
8	GA	Assemble as per Dwg D2804.																							
9	QC5	Inspect work to Step 8																							
10	ST	Identify and Stock																							
11	AC	Cost / part: _____																							
12	DC	Close W/O Inspect Level 21																							

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	
F	05.03.30	MS21043-3 was MS21042L3	KJ/JLM	

RELEASED
05.03.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 20, 2005
03:23 pm

Work Order No : 0023627
Project Name : D2804-042
Project For : WK529
Work Order Type : Main
Main WO Number :
House Part Number : D2804-042
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 06-20-05
Est Finish Date : 07-21-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

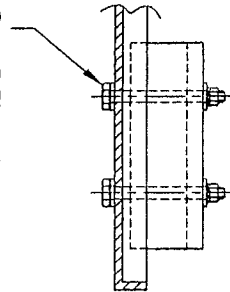
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

CONTROLLED COPY

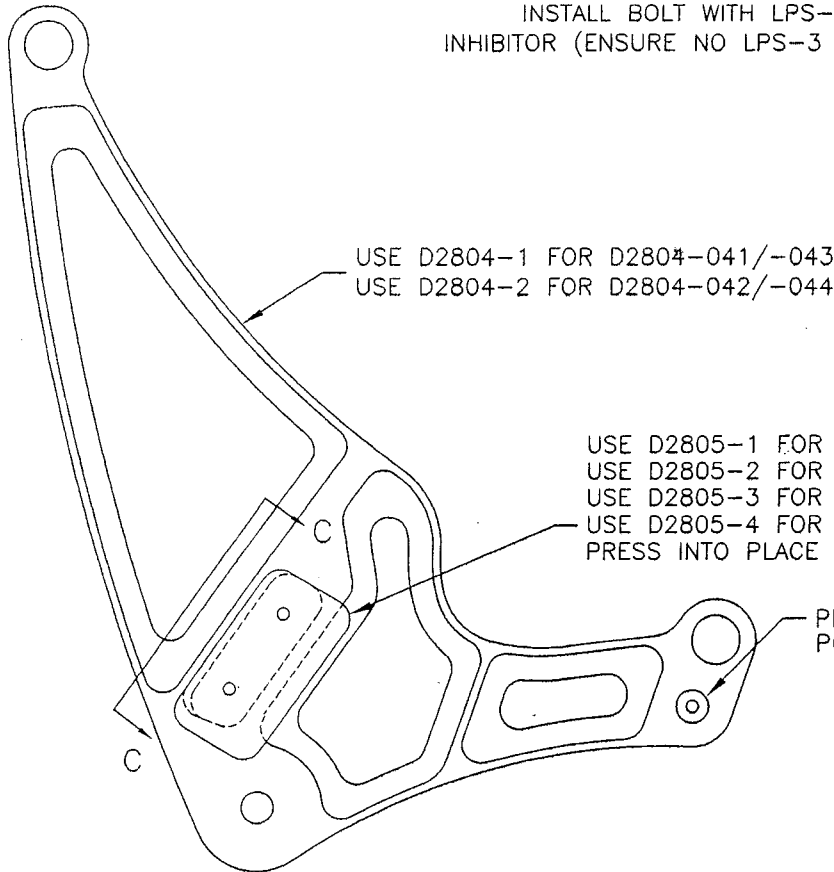


DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)



USE D2804-1 FOR D2804-041/-043
USE D2804-2 FOR D2804-042/-044

USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

RELEASED

05-03-11 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:31 am

Work Order No : 0023627
Project Name : D2804-042
Project For : WK529
Work Order Type : Main
Main WO Number :
House Part Number : D2804-042
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 06-20-05
Est Finish Date : 07-21-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.25	100.00		
Production Cost :	0.00	6.03	100.00	0.00	6.03
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	6.03	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	6.03			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-6.03)

MUS 2/13
u
11-13

Date: Monday, 14/11/2005 8:52:16 AM
 User: Alba Panzuto

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET ASSEMBLY	
Job Number :	23627			
Estimate Number :	10334			
P.O. Number :		Part Number :	D2804042	
This Issue :	14/11/2005	S.O. No. :	Drawing Number :	D2804 REV B
Prsht Rev. :	NC		Project Number :	
First Issue :	/ /	Type :	Drawing Revision :	B
Previous Run :			Material :	
Written By :		Due Date :	15/12/2005	Qty: 10 Um: Each
Checked & Approved By :				
Comment :	Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D28042	STA 155 Bracket
2.0	D28052	Stop
3.0	D2809	Bushing
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Press D2805-2 into arm as per Dwg D2804		
5.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		
6.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		
8.0	AN3C16A	Bolt
9.0	MS210433	Nut
10.0	NAS1515H3	Washer
11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.		

Date: Monday, 14/11/2005 8:52:16 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 23627

Part Number: D2804042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

